

Work Order ID 130315

Wednesday, March 04, 2015 4:16:32 PM

130315

March 11th

Page 1

Item ID: D3075-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw(Foot Print Only)
 Start Date: 3/4/2015 Start Qty: 8.00 ***g*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 8.00 ***g*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 15-3-4 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3075	Rev B								

110 0.00
110 FLOW WATER JET 9 0 Jm15-3-5
 Waterjet Memo 0.00
 FLOW CNC Waterjet CUT BLANK AS PER FILE D3075-1 _BLANK
UHMW 1" BLACK

120 0.00
120 HAAS CNC VERTICAL MACHINING #1 9 BG
 HAAS 1 Memo 0.00 15-6-3-10
 HAAS CNC vertical machine #1 Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining2-Machine as per Folio FA185 and Dwg D3076Identify as D3075-13-Deburr

130 0.00
130 QC2- Inspect parts off machine FAI/FAIB 9 BG
 QC Memo 0.00 15-6-3-10
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00				9	15		DAS 14 9-89 1503/11
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00				9			DAS 27 MAR 19 2015
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ME
5-3-13

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Picklist Print

Wednesday, March 04, 2015 4:16:32 PM

Page 1

Work Order ID: 130315

130315

Parent Item: D3075-1

D3075-1

Parent Item Name: Bearpaw(Foot Print Only)

Start Date: 3/4/2015

Required Date: 3/13/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:C04.02.19 Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
 IPP Rev:D Added C'Bores as per Rev B 07-03-28 JLM
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

100

sf

487.3670

1

MUHMWB10

**

13

Jm15-3-5

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT

394

m131661

394

m131661

MAT018

93.367

m131335

93.367

13

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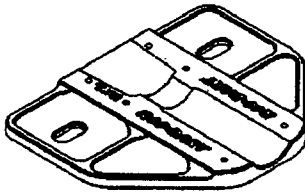
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FAULT CATEGORY

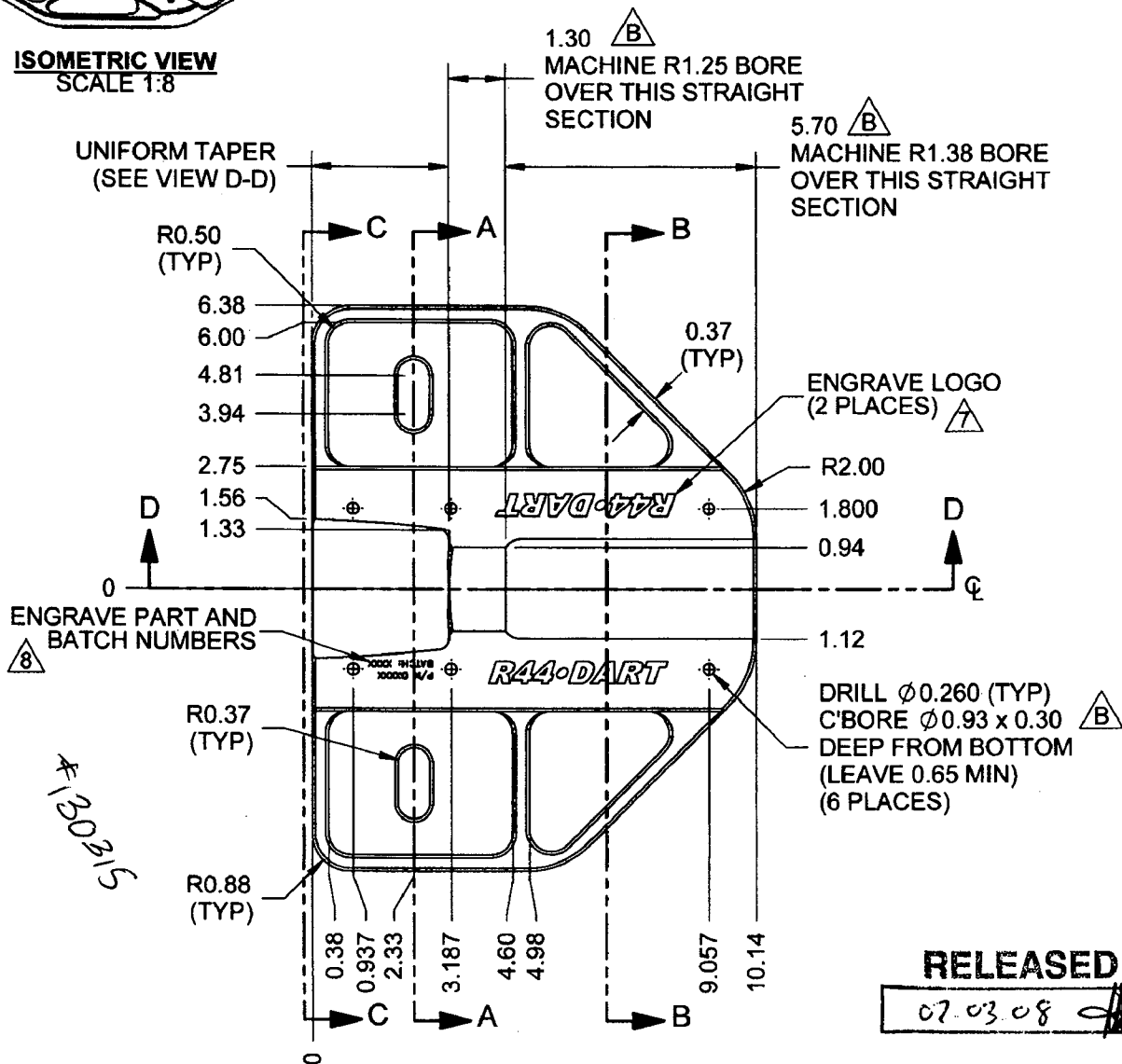
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DART

DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED #1	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27	TITLE R44 BEARPAW	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$; ADD QTY(2) HOLES AT (0.937, ± 1.800)	



ISOMETRIC VIEW
SCALE 1:8



D3075-1 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	130315
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.06	✓		6" Vern	B605
B	0.63	+/-0.030	.645	✓		✓	
C	0.250	+/-0.010	.260	✓		✓	
D	0.950	+0.030/-0.010	.965	✓		✓	
E	5.50	+/-0.030	5.503	✓		✓	
F	0.25 x 45°	+/-0.030	.255	✓		✓	
G	0.900	+/-0.010	.904	✓		✓	
H	0.375	+/-0.010	.385	✓		✓	
I	1.30	+/-0.030	1.30	✓		✓	
J	5.70	+/-0.030	5.70	✓		✓	
K	0.37	+/-0.030	.382	✓		✓	
L	3.600	+/-0.010	3.600	✓		✓	
M	0.260	+0.005/-0.000	.260	✓		✓	
N	0.93	+/-0.030	.929	✓		✓	
O	0.30	+0.030/-0.000	.301	✓		✓	
P	1.08	+/-0.030	1.088	✓		✓	
Q	5.870	+/-0.010	5.87	✓		✓	
R	10.14	+/-0.030	10.14	✓		Tape	B607

Measured by:	<i>JK</i>	Audited by:	DAS 14 9-99	Prototype Approval:	N/A
Date:	15-03-10	Date:	15/03/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	
B	08.01.16	Dwg Rev updated	KJ/EC/DD	<i>[Signature]</i>

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